

Date: Tuesday, 11/29/2005 12:40:51 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 25003A	
Estimate Number : 10163	
P.O. Number : N/A	Part Number : D206642241
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D2650 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : D1
Previous Run : 25002A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/15/2006 Qty: 1 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	B24497 DP05-12-7

2.0	D32861	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-1	Doubler	B24206 BE 05-12-15 1

3.0	D2647	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	B20535 BE 05-12-13

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP05-12-7

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 DP05-12-7

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty	Part Number	Description	Batch
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25003A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R Aluminum Rod m15855/m18901 BE 05-12-13

4-Grind weld flush to cap on top surface only. BE 05-12-14

5-Cut Aft end as per dwg 2650 from front of tube and Deburr BE 05-12-14

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 BE 05-12-14

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. BE 05-12-14

8-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. BE 05-12-15

9- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. BE 05-12-15

10-Remove DT8732, doubler & D206-642-241-T1, then Deburr # 40 rivet holes in tube. BE 05-12-15

11-Re-install D3286-1 doubler using D206-642-241-T1 BE 05-12-15

12-Working from the center out, drill # 40 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. BE 05-12-15

13-Remove and Deburr D3286-1 doubler BE 05-12-15

14-Re-install D3286-1 doubler using D206-642-241-T1 and open to # 30. Cleco each hole being drilled, working from the center out. BE 05-12-15

15-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 BE 05-12-15

16-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder BE 05-12-15

17-Remove indexing edge using DT8741 as per Dwg D2650 BE 05-12-15

18-C'sink GHW rivet holes as per Dwg D2650 BE 05-12-16 1

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12-16

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 *BE 05-12-16 1*

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. *BE 05-12-16 1*

3-Deburr tube and blow out chips from inside the tube *BE 05-12-16 1*

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *A.M 05-12-16 1*

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *M 05/12/16 1*

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid) *Pmc 05-12-16 1*

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid) *Pmc 05-12-16 1*

3-Deburr and blow out all chips from inside the tube *Pmc 05-12-16 1*

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK *25-12-19 1*

11.0 CR3212404 Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet *M 18491*

Pmc 05-12-22 (52)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 25003A

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Job Number:



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12.0	D26543	206 I-Beam (Web)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2654-3	Web	B24749

am 06-01-03 1

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

pm 05-12-22 ①

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-01-03 Time: 11:00 am

Finish Date: 06-01-04 Time: 2:15

BE 06-01-04 ①

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291		m 19134

Sikaflex expire date: 06-06-20

am 06-01-03 ①

14.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

15.0	D2649	Crossbolt Spacer
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Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2649	Crossbolt spacer	B24200

BE 06-01-04 ①

16.0	D32863	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-3	Spacer	B23932

BE 06-01-11 ①

W/O:		WORK ORDER CHANGES					
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Job Number: 25003A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M 15855 BE 06-01-04 (1)

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube BE 06-01-11 (1)

3-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr B.M 06-01-12 (1)

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod BE 06-01-11 (1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets M 1854

a.m 06-01-12 (1)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets M 7808

a.m 06-01-12 (1)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate B 21103

a.m 06-01-12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25003A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Q.m 06-01-12

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

Q.m 06-03-01

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3 Wearpad 248413

FC

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-13 Wearshoe 525324

FC

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-21 Wearshoe 520532

FC 06 03 08

W/O:		WORK ORDER CHANGES					
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Job Number: 25003A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B20756

FC

29.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24117

FC

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

m18293

or (see QSI 017)

FC

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

m19185

FC

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

m16941

FC 060308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D26511	Plug
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-1 Plugs B25010

FC

34.0	D26513	O-Ring
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-3 O-Rings B23491

FC

35.0	MS27039406	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw m68741

FC

36.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer m11151

FC

37.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date: m19597
06 1806

FC

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

FC

3-Install MS27039-4-06 Screw as per DEO 9153.

FC

06 03 08

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect for foreign objects as per QSI 024

FC

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2646 Aft Cap B20208

FC

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 MS27039-1-08 Screw m 16941

FC

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN960JD10L Washer m 19185

FC

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 m 14547
Sikaflex expire date: 06 18 06

FC

FC 06 03 08

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4
Batch: m 0037

FC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 26/03/13

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Handwritten: 03 08 (1)

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 06/03/13 (1)

Job Completion



Handwritten: U 06-03-10

W/O:		WORK ORDER CHANGES					
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